



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5331-041
Job Sheet 180713



Part No: D5331-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: **SOLD**

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27
add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/31/18	0.00	0.00	Start Up Large Fab-6		DC 2018-08-23
100	Large Fab	1 pcs		7/31/18	0.00	15.77	Large Fab 1		
110	QC	1 pcs		7/31/18	0.00	0.00	QC9		18-08-20
120	QC	1 pcs		7/31/18	0.00	0.00	QC5		18-08-20
125	HandFinish	1 pcs		7/31/18	0.00	2.34	HandFinish2		SA 18-09-04
130	Powdercoat	1 pcs		7/31/18	0.00	0.53	Powdercoat2		18-9-5
140	QC	1 pcs		7/31/18	0.00	0.00	QC3		18-09-05
170	Packaging	1 pcs		7/31/18	0.00	0.00	Packaging3-2		18-09-05
180	QC21-SA	1 Ea		7/31/18	0.00	0.00	QC21		18-09-05

Part Op 100 - 1- Assemble ribs and weld as per dwg D5331 using DT10197 ***inspect before welding mesh*** (54.63

Descriptions: CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3- Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate hinge and bracket*** ***On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg (CRITICAL)

130 - 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: 7:50,
OVEN TEMPERATURE: 575° FINISH TIME: 8:05 *****2nd coat if necessary***** 2ND
COAT: START TIME: N/A OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5078989
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3916-5	Light Rib	2 Ea (2 ea)	90-Start up Operation	5091168
D4016-1	Hinge Half, Base	6 Ea (6 ea)	90-Start up Operation	5094864
D4016-7	Stop	1 Ea (1 ea)	90-Start up Operation	5097165
D4021-1	Handle Plate	1 Ea (1 ea)	90-Start up Operation	5070373
D5325-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5064471
D5325-3	Light Rib	1 Ea (1 ea)	90-Start up Operation	5066084
D5325-5	Foot	4 Ea (4 ea)	90-Start up Operation	5101519
D5326-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5065450
D5326-043	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5089123
D5327-1	Rib	1 Ea (1 ea)	90-Start up Operation	58897
D5327-11	Rib	4 Ea (4 ea)	90-Start up Operation	5101863
D5327-13	Rib	1 Ea (1 ea)	90-Start up Operation	5067675

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D5327-15	Cap	1 Ea (1 ea)	90-Start up Operation
D5327-3	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-5	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-7	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-9	Rib	2 Ea (2 ea)	90-Start up Operation
D5328-3	Mesh Base, Aft	1 Ea (1 ea)	90-Start up Operation
D5328-5	Mesh Base, Fwd	1 Ea (1 ea)	90-Start up Operation
D5329-1	Gusset	2 Ea (2 ea)	90-Start up Operation
D5330-1	Handle Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

161209
SO65574
SO65588
SO5102975
SO65631
SO94851
SO94849
SO89969
SO54668
SO70545

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	59	0
	D3913-15	1	4	0
	D3916-5	2	13	0
	D4016-1	6	34	0
	D4016-7	1	2	0
	D4021-1	1	57	0
	D5325-041	1	2	0
	D5325-3	1	3	0
	D5325-5	4	4	0
	D5326-041	1	3	0
	D5326-043	1	2	0
	D5327-1	1	4	0
	D5327-11	4	4	0
	D5327-13	1	11	0
	D5327-15	1	3	0
	D5327-3	1	3	0
	D5327-5	1	3	0
	D5327-7	1	1	0
	D5327-9	2	6	0
	D5328-3	1	2	0
	D5328-5	1	0	0
	D5329-1	2	12	0
	D5330-1	2	10	0
	M304EX0.75-16F	32	837	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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UART Aerospace Ltd.
 1270 Aberdeen Street
 Cambridge, ON K4A 1K7
 CANADA
 TEL: 513 632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S103529

Part: D5331 - 041

Job No: 180713

Serial No/Batch: S103529

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Date: 08/20/18

ILT CATEGORY

Inqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence